

Work Order ID 60222

Tuesday, June 29, 2010 11:38:00 AM



Page 1

Item ID: D3303-041

Revision ID:

Item Name: Head Rest

Start Date: 6/29/2010 Start Qty: 2.00

Required Date: 7/6/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-6-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3303

Rev B

100



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L adhesive. Identify as D3303-041 A/R 3M 1300/1300L Adhesive Batch 1113174 2- Cover Head Rest with D3306-041 as per Dwg D3303

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

120



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock Location: 186

EB 10/06/30 (3)

(x3)

10.7-2 SP (32)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60222

Tuesday, June 29, 2010 11:38:00 AM



Page 2

Item ID: D3303-041

Revision ID:

Item Name: Head Rest

Start Date: 6/29/2010 Start Qty: 2.00

Required Date: 7/6/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*POCUT**ME**10-7-6*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|--------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:38:04 AM

Page 1

Work Order ID: 60222

Parent Item: D3303-041

Parent Item Name: Head Rest

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B 04.10.05 Revised Step 5 with headrIPP identification KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3303-043 Bracket Assembly | | Manufactured | No | | | 100 | Each | 12.0000 | 1 | 2 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST186 | | | | 12 | | | | | |
| | | | | | 58913 | | | 12 | | | | | |
| D3305-1 Cushion | | Manufactured | No | | | 100 | Each | 3.0000 | 1 | 2 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST184 | | | | 3 | | | | | |
| | | | | | | | | 3 | | | | | |
| D3306-041 Cover Assembly | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 2 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST184 | | | | 4 | | | | | |
| | | | | | 40910 | | | 1 | | | | | |
| | | | | | 54441 | | | 3 | | | | | |

3 10/06/30

3 10/06/30

3 10/06/30

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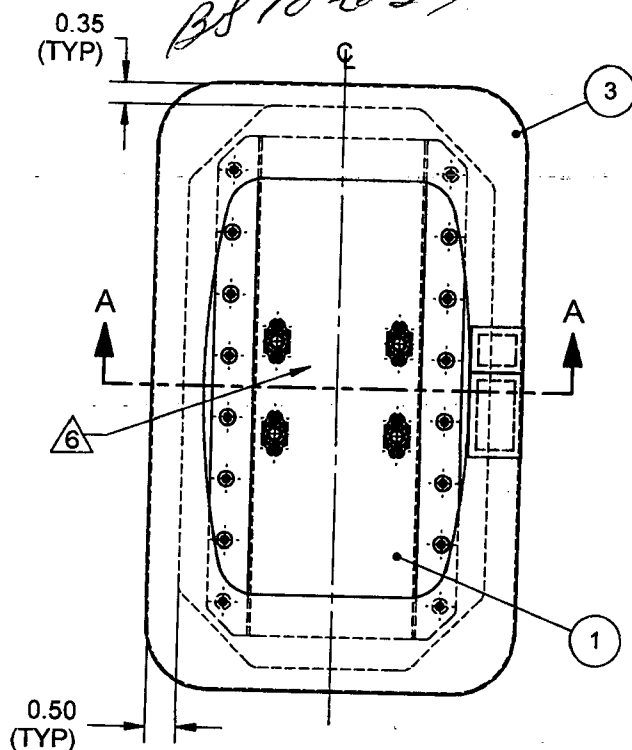
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *00222*

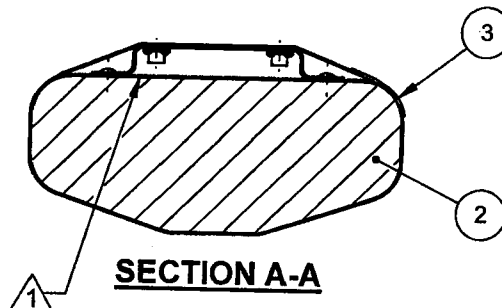
38106-29



RELEASED

dc 09.19

DEO ATTACHED



D3303-041 HEAD REST

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------|
| | X | D3303-041 | HEAD REST |
| 1 | 1 | D3303-043 | BRACKET ASSEMBLY |
| 2 | 1 | D3305-1 | FOAM |
| 3 | 1 | D3306-041 | COVER ASSEMBLY |

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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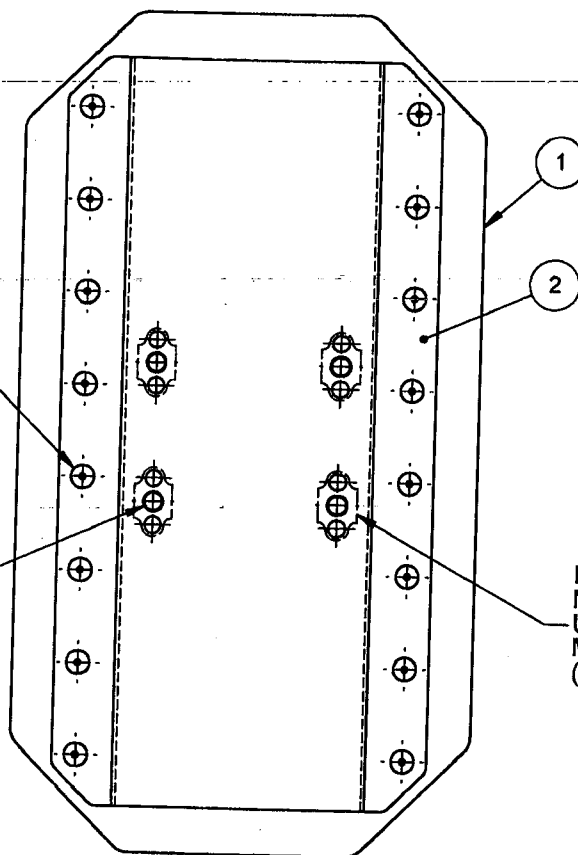
NOTE: Date & initial all entries



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|------------------------------|--------------------------------|--|--------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | REV. B |
| DATE 06.08.17 | | TITLE HEAD REST | SHEET 2 OF 4 |
| | | | SCALE 1:2 |

INSTALL ITEM ⑤
MS20470AD4-4 RIVETS
(16 PLACES)

MASK THREADS
PRIOR TO PAINT
(4 PLACES)

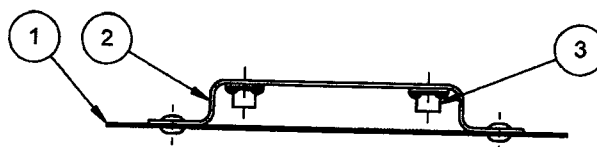


INSTALL ITEM ③
MS21075L3 NUT PLATE (1)
USING ITEM ④
MS20426AD3-3 RIVET (2)
(4 PLACES)

DEO ATTACHED

RELEASED

06.09.19



D3303-043 BRACKET ASSEMBLY

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|--------------|------------------|
| | X | D3303-043 | BRACKET ASSEMBLY |
| 1 | 1 | D3303-1 | PLATE |
| 2 | 1 | D3303-3 | HEAD REST |
| 3 | 4 | MS21075L3 | NUT PLATE |
| 4 | 8 | MS20426AD3-3 | RIVET |
| 5 | 16 | MS20470AD4-4 | RIVET |

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

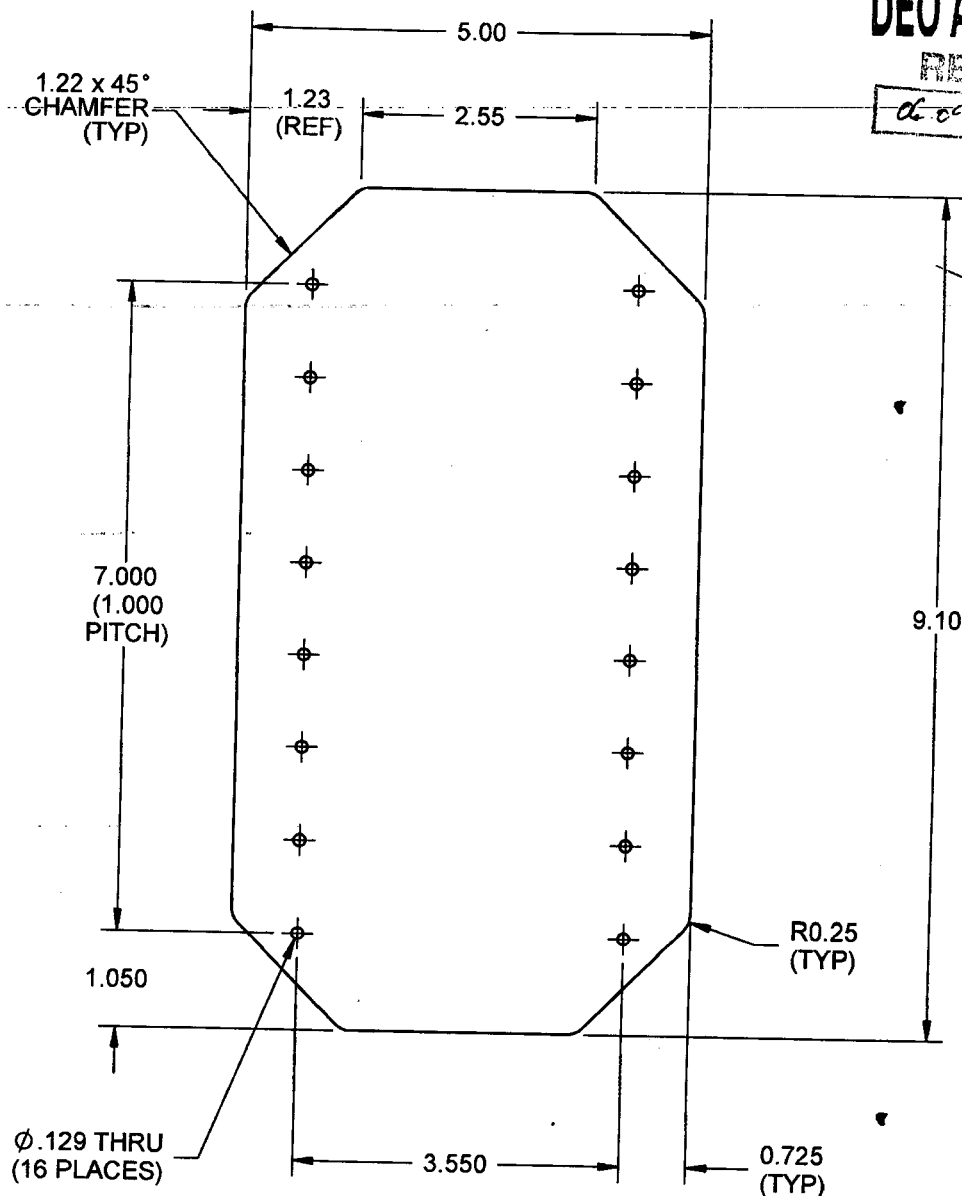
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NOTE: Date & initial all entries



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| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | REV. B |
| DATE 06.08.17 | | TITLE HEAD REST | SHEET 3 OF 4 |
| | | | SCALE 1:2 |



D3303-1 PLATE

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

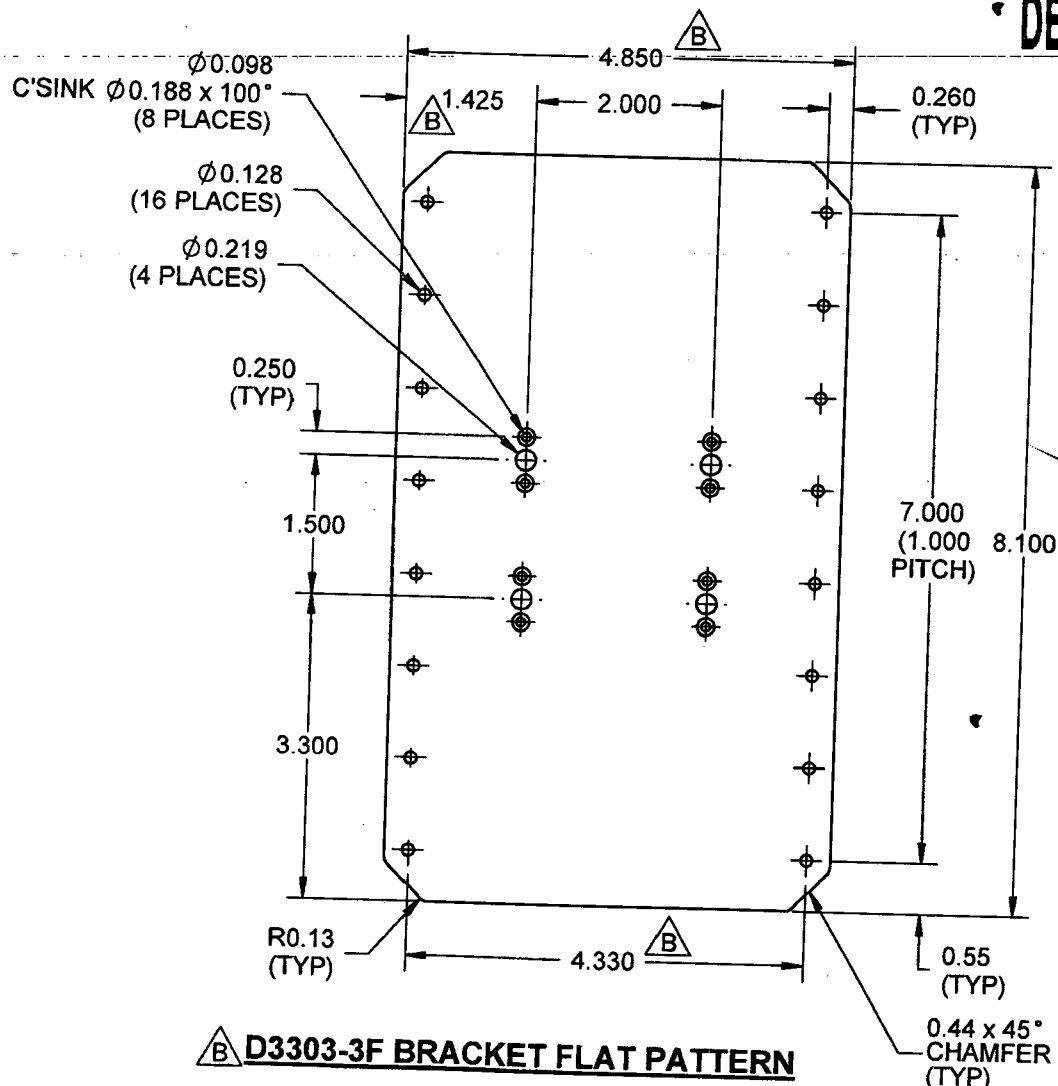
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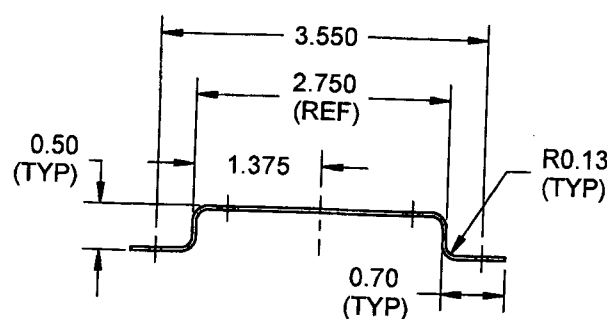


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| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. B |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | SHEET 4 OF 4 |
| DATE 06.08.17 | TITLE HEAD REST | SCALE 1:2 | |

DEO ATTACHED



D3303-3F BRACKET FLAT PATTERN



D3303-3 BRACKET BEND DETAIL

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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|----------------------|---------------------|------------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3303 | TITLE HEAD REST | REV. B | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3303-B-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED <i>h</i> | MFG. APPR. <i>h</i> | APPROVED <i>h</i> | | DE APPR. <i>h</i> | | |
| DATE 08.10.15 | DATE 08.10.15 | DATE 08/10/16 | DATE 08/10/16 | | DATE 08/10/16 | | |

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

IS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

WAS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SEE NCR 08-069 FOR FURTHER DETAILS

wlo 40220

RELEASED
08/11/16

| W/O: | | WORK ORDER CHANGES | | | | | | |
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